Practice quiz: AWS CWI/SCWI Endorsement: Welding Procedure Qualifier (WPQ2)

10 questions. The answer key is on page 2.

Name _____ Date _____

1. **Under D1.1, who sets a toughness requirement that a WPS must meet?**
   A. The Engineer, in the contract documents
   B. The welder, during the qualification test
   C. The Inspector, after the visual inspection
   D. The filler metal supplier, on its certificate

2. **A job is under D1.1, statically loaded, with no toughness requirement. The joints are prequalified details, the steel is listed, and the process is FCAW with gas shielding. What should you check next before calling the WPS prequalified?**
   A. Whether a PQR exists for each joint
   B. Whether the welders passed a bend test on that steel
   C. Filler matching, preheat and the variable limits for the process
   D. Whether the Engineer has tested the steel's toughness

3. **Production members on a job go up to 40 mm thick. Why does the test plate thickness matter when you plan the procedure test?**
   A. It sets which welders may take the test
   B. It sets the thickness range the WPS can cover
   C. It decides the filler metal classification
   D. It decides whether visual inspection is needed

4. **A question gives this rule from a fictional standard: a procedure test in the flat position qualifies flat and horizontal welding. Production includes horizontal fillet welds and vertical groove welds. Under that rule, which production welds does a flat test leave unqualified?**
   A. The horizontal fillet welds
   B. Both kinds of production welds
   C. Neither kind of production weld
   D. The vertical groove welds

5. **During a procedure test the welding machine's panel meter cannot be trusted. Which of these confirms the welding current?**
   A. A voltmeter connected across the arc
   B. The wire feed speed shown on the feeder
   C. A calculation from arc voltage and travel speed
   D. A clamp-on ammeter on the welding lead

6. **When is a procedure test weld inspected visually and by NDT?**
   A. After the bend specimens have been tested
   B. Before the mechanical test specimens are cut
   C. Only if one of the specimens fails
   D. Only on production welds, never on the test weld

7. **Why is weld reinforcement removed from bend specimens as D1.1 requires?**
   A. So the specimen fits in the tension test machine
   B. To show the welder's cap profile more clearly
   C. Left on, it changes how the specimen bends and so the result
   D. To meet the visual acceptance criteria for the cap

8. **Which statement about a PQR is right?**
   A. It records actual values and test results
   B. It gives the welder's ranges
   C. It is revised whenever production values change
   D. It replaces the WPS at the welding station

9. **A PQR was welded in the flat position. Suppose the rule (invented for this question) is that a procedure test qualifies only the position tested. Which production positions does the WPS support?**
   A. Flat and horizontal
   B. Flat only
   C. All positions
   D. Vertical only

10. **On a job with a CVN requirement, a draft WPS allows heat input well above the PQR's value. Why is that a concern?**
    A. Higher heat input always raises toughness, so it is no concern
    B. Heat input has no effect on toughness at all
    C. Heat input matters only for fillet welds
    D. Higher heat input can lower toughness, so the range is limited

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Answer key

AWS CWI/SCWI Endorsement: Welding Procedure Qualifier (WPQ2). One line of why for each answer.

1. **A** Requirements such as toughness come from the Engineer through the contract documents, and the Contractor's WPS must meet them.
2. **C** The stem settles the process, steel and joint, but a prequalified WPS also needs matching filler, the required preheat and values inside the variable limits table.
3. **B** A procedure test plate qualifies a thickness range, so it must be chosen to cover the thickest production member.
4. **D** The stated rule covers flat and horizontal, so the horizontal fillets are covered and the vertical groove welds are not.
5. **D** Current is measured with an ammeter, and a calibrated clamp-on unit on the welding lead reads it without breaking the circuit.
6. **B** The test weld is inspected visually and by NDT before specimens are cut, so a weld that fails there is not tested further.
7. **C** Extra metal on the face changes the strain in the bend, so it is removed to test the weld fairly.
8. **A** A PQR records what was done in the test and what the tests showed.
9. **B** Under the stated rule the test qualifies only the position tested, so the WPS supports flat only.
10. **D** High heat input slows cooling and can coarsen the grain, which can lower toughness, so when CVN testing applies the heat input range is limited.

Full explanations

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